

Date: Thursday, 4/12/2007 8:44:56 AM
User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|-------------------------------------|----------------|--|--|--|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | SADDLE FITTING, AFT (OUTBOARD/INBOARD) | | |
| Job Number | 31717 | Part Number | D2573 | | |
| Estimate Number | 10533 | Drawing Number | D2573 REV E | | |
| P.O. Number | N/A | Project Number | N/A | | |
| This Issue | 4/12/2007 | S.O. No. | N/A | | |
| Prsht Rev. | NC | Type | MACHINED PARTS | | |
| First Issue | N/A | Material | N/A | | |
| Previous Run | 30594 | Due Date | 4/30/2007 Qty: 12 Um: Each | | |
| Written By | | | | | |
| Checked & Approved By | | | | | |
| Comment | Est: 1 As Per RevE 06-01-27 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|--|
| 1.0 | D6101007 | 7075-T7351 8.25X7.75X2.5 | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B25354</u> <u>X12</u> | |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B31717</u> Double check by: <u>SC</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. | |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE | |
| | | Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:44:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 31717

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 07/05/09

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD

07/05/09 (12)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



(12X)

m-l 07/05/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ergos 10



9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ergos 10 (12)



10.0 QC21 FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

RJ 07/05/11

Job Completion



W JW 07/05/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31717 |
| Description: Saddle, Aft Outboard | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 |

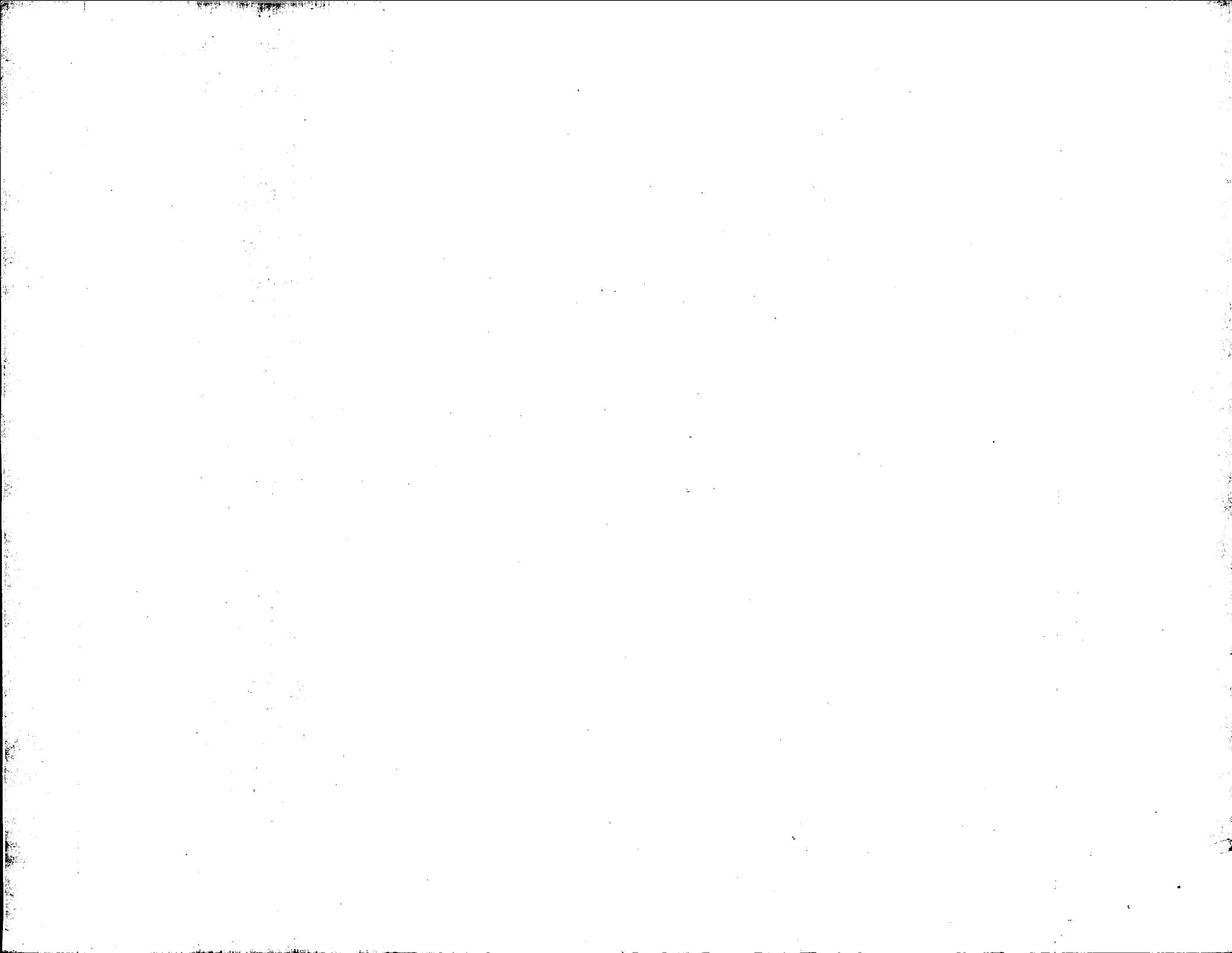
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.749 | 1.748 | 1.750 | 1.749 | | |
| C | 3.495 | 3.505 | | 3.499 | 3.500 | 3.499 | 3.499 | | |
| D | 1.745 | 1.755 | | 1.749 | 1.748 | 1.750 | 1.749 | | |
| E | 7.990 | 8.010 | | 8.004 | 8.003 | 8.003 | 8.004 | | |
| F | 0.490 | 0.510 | | 0.497 | 0.496 | 0.499 | 0.500 | | |
| G | 0.257 | 0.262 | DT8683 | 0.260 | 0.260 | 0.260 | 0.260 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.499 | 0.502 | 0.503 | 0.502 | | |
| J | 1.174 | 1.184 | | 1.177 | 1.176 | 1.179 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.562 | 0.566 | 0.565 | 0.565 | | |
| L | 1.174 | 1.184 | | 1.177 | 1.176 | 1.179 | 1.177 | | |
| M | 1.365 | 1.375 | | 1.367 | 1.368 | 1.366 | 1.366 | | |
| N | 2.495 | 2.505 | | 2.498 | 2.496 | 2.497 | 2.498 | | |
| O | 4.119 | 4.129 | | 4.121 | 4.124 | 4.121 | 4.121 | | |
| P | 0.115 | 0.135 | | 0.128 | 0.127 | 0.128 | 0.126 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.252 | 0.252 | 0.253 | 0.252 | | |
| S | 0.115 | 0.135 | | 0.129 | 0.126 | 0.126 | 0.127 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.238 | 0.242 | 0.242 | 0.239 | | |
| W | 0.115 | 0.135 | | 0.132 | 0.135 | 0.131 | 0.129 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.367 | 0.362 | 0.362 | 0.360 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.628 | 0.625 | 0.627 | 0.628 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.249 | 0.250 | 0.249 | 0.250 | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.512 | 1.513 | 1.513 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.261 | | |
| AH | 0.240 | 0.260 | | 0.252 | 0.257 | 0.249 | 0.248 | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.002 | 2.003 | 2.002 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.037 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

Measured by: *EN*
Date: *07.05.05*

Audited by: *RA*
Date: *07.05.06*

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------------|-----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM <i>JK</i> | <i>JK</i> |



| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31717 |
| Description: Saddle, Aft Outboard | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.748 | 1.748 | 1.748 | 1.748 | | |
| C | 3.495 | 3.505 | | 3.499 | 3.500 | 3.500 | 3.497 | | |
| D | 1.745 | 1.755 | | 1.748 | 1.748 | 1.748 | 1.748 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.003 | 8.004 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.501 | 0.503 | 0.498 | 0.497 | | |
| G | 0.257 | 0.262 | DT8683 | 0.260 | 0.260 | 0.260 | 0.260 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.501 | 0.503 | 0.500 | 0.500 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.175 | 1.177 | | |
| K | 0.558 | 0.578 | | 0.566 | 0.566 | 0.565 | 0.567 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.175 | 1.177 | | |
| M | 1.365 | 1.375 | | 1.369 | 1.369 | 1.369 | 1.369 | | |
| N | 2.495 | 2.505 | | 2.499 | 2.497 | 2.497 | 2.499 | | |
| O | 4.119 | 4.129 | | 4.122 | 4.121 | 4.121 | 4.123 | | |
| P | 0.115 | 0.135 | | 0.126 | 0.127 | 0.127 | 0.127 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.252 | 0.251 | 0.252 | 0.252 | | |
| S | 0.115 | 0.135 | | 0.127 | 0.127 | 0.130 | 0.126 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | 3230 | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.238 | 0.238 | 0.240 | 0.240 | | |
| W | 0.115 | 0.135 | | 0.129 | 0.129 | 0.133 | 0.131 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.310 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.362 | 0.362 | 0.362 | 0.362 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.626 | 0.626 | 0.624 | 0.627 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.246 | 0.246 | 0.247 | 0.249 | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.512 | 1.512 | 1.512 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.270 | 0.257 | 0.250 | 0.249 | | |
| AI | 2.000 | 2.020 | | 2.001 | 2.001 | 2.002 | 2.002 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.032 | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | CD | Audited by: | SD |
| Date: | 07/05/06 | Date: | 07/05/06 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | CD |

| | | |
|-----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 31717 |
| Description: Saddle, Aft Outboard | Part Number: | D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 |

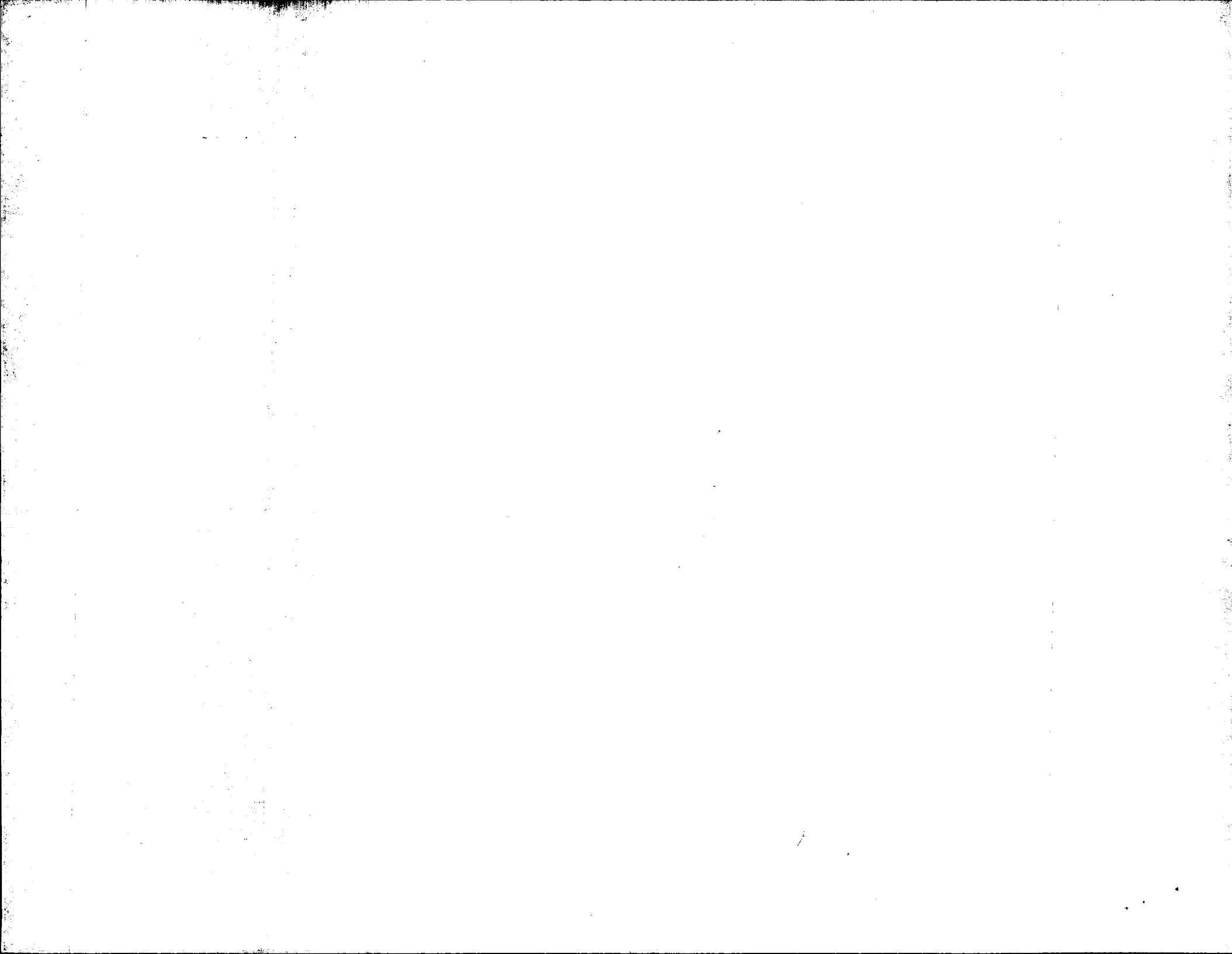
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

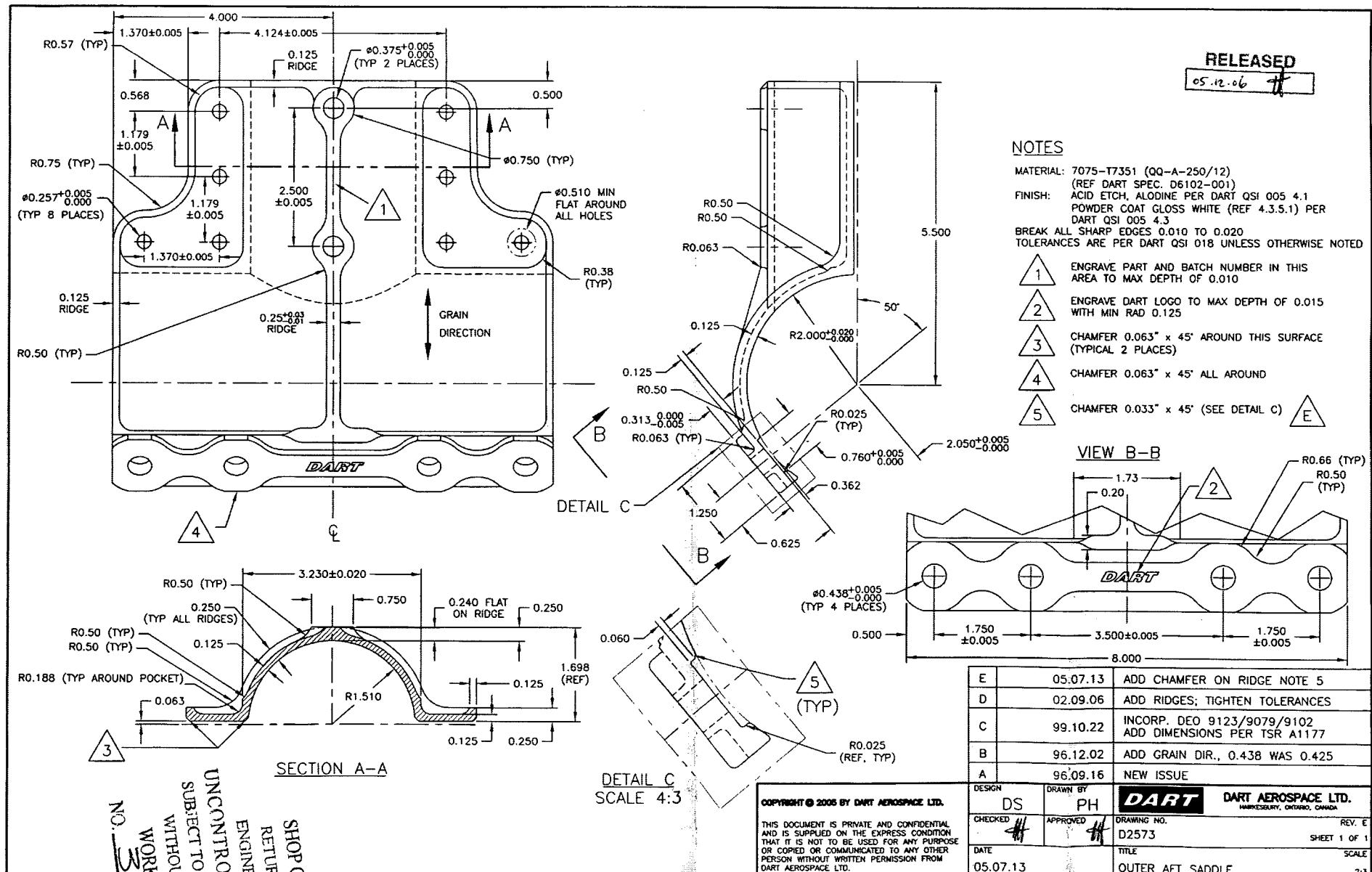
| | | | | Recorded Actual Dimensions | | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|--|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | | |
| B | 1.745 | 1.755 | | 1.748 | 1.749 | 1.750 | 1.750 | | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | | |
| D | 1.745 | 1.755 | | 1.748 | 1.749 | 1.748 | 1.748 | | | |
| E | 7.990 | 8.010 | | 8.003 | 8.001 | 8.001 | 8.001 | | | |
| F | 0.490 | 0.510 | | 0.501 | 0.502 | 500 | .500 | | | |
| G | 0.257 | 0.262 | DT8683 | 0.260 | 0.260 | 0.260 | 0.260 | | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | | |
| I | 0.490 | 0.510 | | 0.503 | 0.501 | .500 | .500 | | | |
| J | 1.174 | 1.184 | | 1.178 | 1.175 | 1.179 | 1.179 | | | |
| K | 0.558 | 0.578 | | 0.566 | 0.566 | .565 | .565 | | | |
| L | 1.174 | 1.184 | | 1.178 | 1.175 | 1.178 | 1.178 | | | |
| M | 1.365 | 1.375 | | 1.366 | 1.367 | 1.367 | 1.367 | | | |
| N | 2.495 | 2.505 | | 2.497 | 2.497 | 2.500 | 2.500 | | | |
| O | 4.119 | 4.129 | | 4.121 | 4.121 | 4.122 | 4.122 | | | |
| P | 0.115 | 0.135 | | 0.126 | 0.128 | .128 | .128 | | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | | |
| R | 0.240 | 0.260 | | 0.252 | 0.253 | .252 | .252 | | | |
| S | 0.115 | 0.135 | | 0.123 | 0.127 | .125 | .125 | | | |
| T | 0.178 | 0.198 | | 0.189 | 0.188 | 0.188 | 0.188 | | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | | |
| V | 0.230 | 0.250 | | 0.238 | 0.237 | .238 | .238 | | | |
| W | 0.115 | 0.135 | | 0.132 | 0.132 | .132 | .132 | | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | .312 | .312 | | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | | |
| Z | 0.352 | 0.372 | | 0.367 | 0.365 | .368 | .365 | | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | | |
| AB | 0.615 | 0.635 | | 0.626 | 0.628 | .628 | .628 | | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | | |
| AD | 0.240 | 0.260 | | 0.248 | 0.247 | .249 | .248 | | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.513 | 1.517 | 1.512 | | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | | |
| AH | 0.240 | 0.260 | | 0.250 | 0.251 | .251 | .251 | | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.003 | 2.002 | 2.002 | | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | | |
| Accept/Reject | | | | | | | | | | |

Measured by: *EP / MS*
Date: *07/05/08*

Audited by: *J.L.*
Date: *07/05/08*

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|---------------------------|--------------------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |





SHOP COPY
 RETURN TO
 ENGINEERING
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 WITHOUT
 WORK ORDER
 NO. 3 [REDACTED]

